

Work Order ID 106540

Thursday, September 05, 2013 3:26:05 PM

106540

Ship Sept 12th

Page 1

Item ID: D412-786-011 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Hard Point
 Start Date: 9/5/2013 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 9/12/2013 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: MF Date: 13-09-05 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
	<u>MS</u>

100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D412-786-011 chg001								

DAS
06
9-8

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

IX

SP
13-9-9

120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

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Item ID: D412-786-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Hard Point

Stop ***NS2***Start Date: 9/5/2013 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/12/2013 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-786-011								
	Location: _____								
	PPP Rev: _____ SHIP								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

B/9/11 **SD****MLJ** **13-09-11****QB-09-11**

Picklist Print

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Work Order ID: 106540

Parent Item: D412-786-011

Parent Item Name: Hard Point

Start Date: 9/5/2013

Required Date: 9/12/2013

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 12-04-27 JLM VERIFIED BY:DD

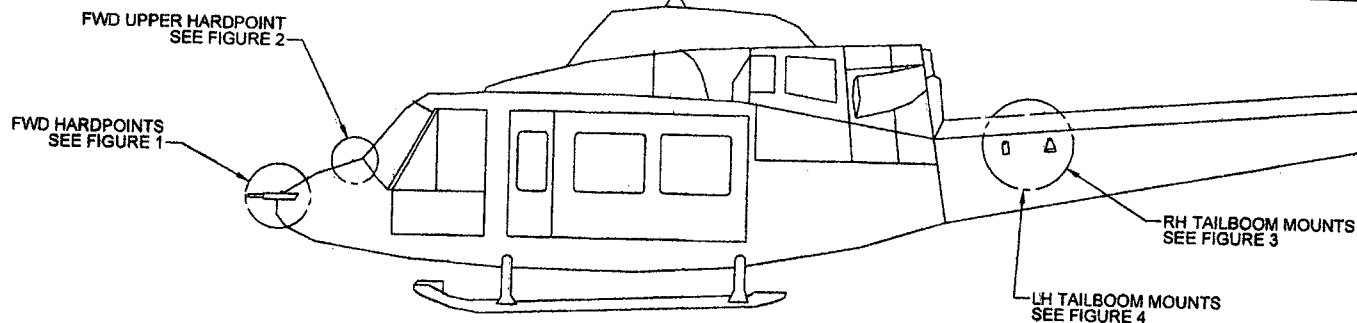
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D412-786-013 Fwd Hardpoint Installation		Manufactured	No				Each	0.0000		1		B106541	SP
D412-786-015 Tailboom Mount		Manufactured	No				Each	0.0000		1		B106542	SP

SP 13-9-9.

DAS
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9-88

REFERENCE ONLY

13/9/11



D412-786-011 HARDPOINT KIT

QTY -011	QTY -013	QTY -015	PART NUMBER	DESCRIPTION
1	1		D412-786-011	HARDPOINT KIT
1	1		D412-786-013	FWD HARDPOINT KIT
		X	D412-786-015	TAILBOOM MOUNT KIT
		1	D3866-041	TAILBOOM MOUNT
		2	D3866-043	TAILBOOM MOUNT
			D3870-041	FWD LH HARDPOINT
			D3870-042	FWD RH HARDPOINT
			D3870-5	FWD UPPER HARDPOINT
		1	D3871-1	DOUBLER
		1	D3871-2	DOUBLER
10	12		MS21042L3	NUT
8	12		MS27039-1-11	SCREW
			MS27039-1-12	SCREW
			MS27039-1-14	SCREW
10	124		NAS1149D0332J	WASHER

INSTALLATION	WEIGHT	LONGITUDINAL		LATERAL	
		ARM	MOMENT	ARM	MOMENT
D412-786-011 HARDPOINT KIT	0.58 LBS 0.22 KG	164.67 IN 4.18 M	95.51 IN 0.92 KG-M	-1.25 IN -0.03 M	-0.73 IN-LB -0.007 KG-M
D412-786-013 FWD HARDPOINT KIT	0.22 LBS 0.08 KG	-13.55 IN -0.34 M	-2.98 IN-LB 0.03 KG-M	2.36 IN 0.06 M	0.52 IN-LB 0.005 KG-M
D412-786-015 TAILBOOM MOUNT KIT	0.36 LBS 0.13 KG	273.58 IN 6.95 M	88.49 IN-LB 0.90 KG-M	-3.47 IN -0.09 M	-1.25 IN-LB -0.01 KG-M

RELEASED
07/6/13

NOTES:

- 1) D412-786-011 HARDPOINT KIT REQUIRED ON 412/412EP AIRCRAFT UTILIZING D412-695-011 BLADE FOLDING KIT WHERE WIRE STRIKE COMPATIBILITY IS REQUIRED
- 2) TOUCH UP DRILLED HOLES WITH ALODINE PER THE AIRCRAFT MAINTENANCE MANUAL
- 3) TORQUE FASTENERS AS FOLLOWS: 10-32, 20-25 IN-LBS
- 4) PRIME AND PAINT HARDPOINTS TO MATCH AIRCRAFT PAINT SCHEME PER AIRCRAFT MAINTENANCE MANUAL

A NEW ISSUE		09.01.14
REV	DESCRIPTION	DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.01.14	
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWING NO. D412-786-1		REV. A
TITLE HARDPOINT KIT INSTALL		SHEET 1 OF 5
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Shut Sep

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120									
QC	Memo	0.00							
Quality Control									

11/13-09-10

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SP
13-9-9